










204.618

Dart Aerospace Ltd.

Date: Tuesday, 07/04/2009 10:18:09 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP WELDMENT
Job Number	: 46951		
Estimate Number	: 11123		
P.O. Number	:	Part Number	: D2460
This Issue	: 07/04/2009 S.O. No. :	Drawing Number	: D2460 REV D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	: D
Previous Run	: 34987	Material	:
Written By	:	Due Date	: 23/04/2009 Qty: 4 Um: Each
Checked & Approved By	: <u>JUL 09.04.07</u>		
Comment	: Est Rev: F Added Finish as per Rev D 05-11-30 JLM		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
✓ 1.0	D2244116	Step Extrusion	
			
Comment: Qty.: 0.5000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Qty Part # Description Batch .5 D2244 Step Extrusion <u>B38023 (1)</u> <u>B33733 (1)</u>			
2.0	D23381	204 Step Lug	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: Qty Part Number Description Batch No. 1 D2338-1 End cap <u>B34992</u>			
3.0	D23382	204 Step Lug	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: Qty Part Number Description Batch No. 1 D2338-2 End cap <u>B34993</u>			
4.0	D2459	Angle	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: Qty Part Number Description Batch No. 1 D2459 Lug <u>B33233 = 2</u> <u>B47111 = 2</u>			

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 07/04/2009 10:18:09 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 46951

Part Number: D2460

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



(Pb) 7

Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2244 per Dwg. D2460

2-Weld as per Dwg. D2460 (use DT8793 to locate D2459)

A/R Alum rod

Batch: M110130

M110431

3-Deburr

SAD 09-04-08 (4)

PL 09-04-21 4

PL 09-04-21 4

6.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 01/04/21

7.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

BE 09-04-21 (4)

8.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

PL 09-04-23 4

9.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

touch up alodine - FL 09/04/23 (4)

M110439

START TIME: 9:30

OVEN TEMPERATURE: 320°

FINISH TIME: 10:00

BR 09-04-24 (4)

10.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk per dwg D2460

Batch: M111013

W 09-04-24 (4)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
	#71	7.1 welds as per AS7004						
9/4/21	#71	Alodine as per distro 5 SAD 09-04-21 x 4	<i>[Signature]</i>	09/04/21			<i>[Signature]</i> 09/04/21	
	#72	Remove Alodine at one end per welding SAD 09-04-23	<i>[Signature]</i>	10/11/21			<i>[Signature]</i> 09/04/21	
	#73	Weld D2459 as per Dwg and as per AS7004 A/R # <u>M110130</u> D2459 BA <u>333233</u>	<i>[Signature]</i>	09-04-23			<i>[Signature]</i> 09/04/21	
	#74	QC 9 inspect weld	<i>[Signature]</i>	10/11/21			<i>[Signature]</i> 09/04/21	
	#75	QC 5 inspect work in current step <i>[Signature]</i> 09/04/23 (X4)	<i>[Signature]</i>	10/11/21			<i>[Signature]</i> 09/04/21	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: STEP WELDMENT

Job Number: 46951

Part Number: D2460

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(4)

Comment: Inspect Powder Coat and Wing Walk

FD 09/04/27

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PPP 468A

FD 09/04/27 (4)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



09/04/28

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-04-28

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DART AEROSPACE LTD
HAMKESBURY, ONTARIO, CANADA

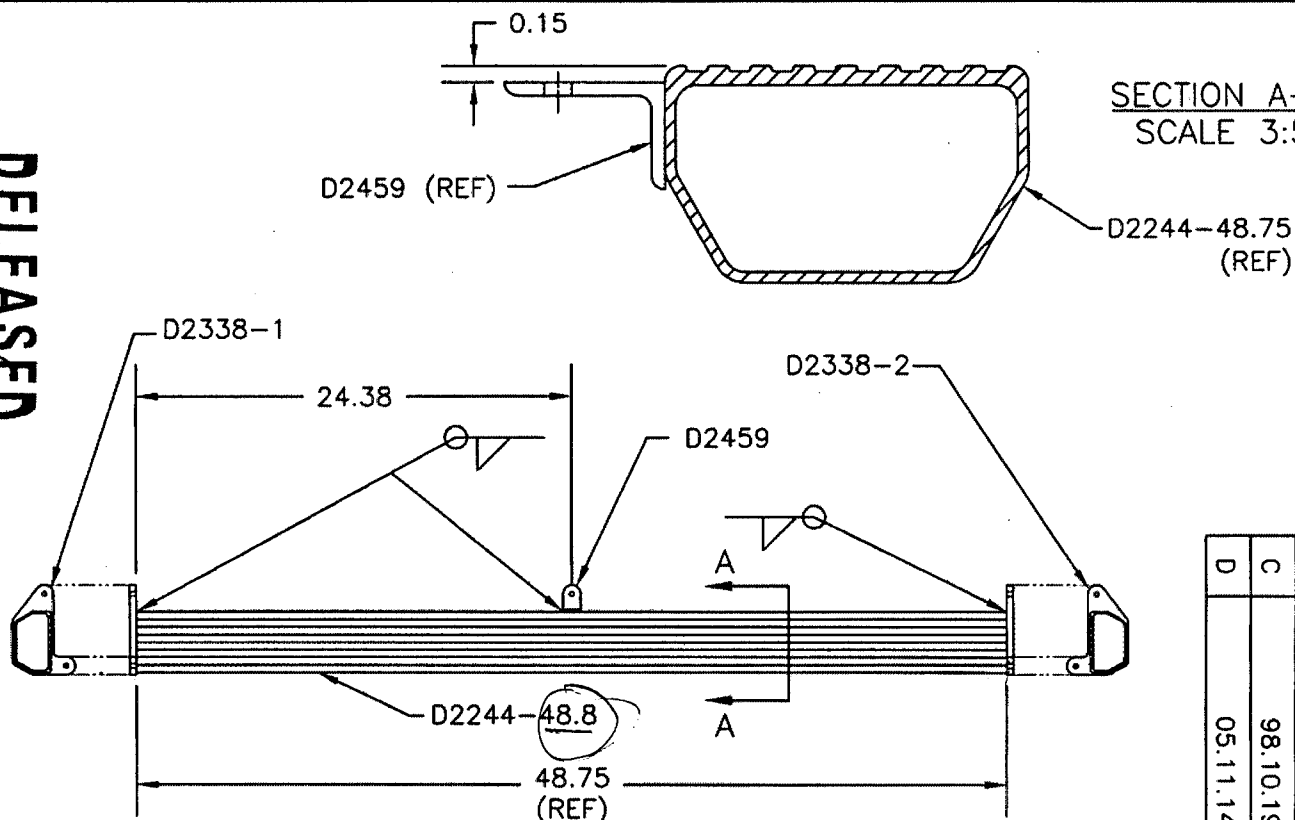
REV. D

SHEET 1 OF 1

DESIGN	DRAWN BY	DART AEROSPACE LTD
BW	HJ	
CHECKED	APPROVED	DRAWING NO.
HJ	HJ	D2460
DATE	TITLE	SCALE
05.11.14	STEP WELDMENT ASSEMBLY	1:10

A	95.01.25	NEW ISSUE
B	96.03.29	CHANGE END PLATES
C	98.10.19	ADDED SECTION A-A (TSR A915)
D	05.11.14	UPDATE FINISHING NOTES

SECTION A-A
SCALE 3:5



D2460 STEP WELDMENT ASSEMBLY PARTS LIST

P/N	DESCRIPTION	QTY
D2460	STEP WELDMENT ASSEMBLY	X
D2244-48.8	EXTRUSION*	1
D2338-1	ENDPLATE	1
D2338-2	ENDPLATE	1
D2459	ANGLE	1

*cut per drawing

D2460 STEP WELDMENT ASSEMBLY NOTES

- 1) MAKE FROM EXTRUSION D2244
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.4
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.4
BLACK ANTI-SKID TOP SURFACE TO BOTTOM OF
RADIUS PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

NO WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

RELEASED
05.11.28